: FWD ADJUSTABLE BLADE SUPPORT A

: PB674300115

: B6743001 P.7

: N/A

: 24/07/2008

: B1

Date: User Thursday, 24/07/2008 8:23:49 AM

Melanie Fauteux

**Process Sheet** 

**Drawing Name** 

Part Number

**Drawing Number** 

Project Number

**Drawing Revision** 

Material

**Due Date** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 40608 -

**Estimate Number** 

P.O. Number

Previous Run

This Issue : 24/07/2008

Prsht Rev. : NC

First Issue

Checked & Approved By

: 17/07/2008

: 13433

Type

S.O. No. :

: LARGE FAB ASSY

Comment

Written By

: Est Rev:A 08-06-26 new issue DD verified by:ec

**Additional Product** 

Job Number:

Seq. #:

Machine Or Operation:

Description: Inner Tube

1.0

2.0

PB6743001257

Comment: Qty.: 1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Inner Tube,

batch: 40.585 PB6743001249

Inner Tube Bushing

Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Inner Tube Bushing batch: m12147

PB6743001253

Gusset



Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Gusset

PB6743001254

batch: 340042

Gusset



Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Gusset

batch: 340053

PB67430017

PB67-43001-71



Comment: Qty.:

5.0

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

PB67-43001-71 batch:









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## **Process Sheet**

.omer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

QC9 7.0

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

INSPECT WORK TO CURRENT STEP



8.0



WORK TO CURRENT STEP Comment: INSPE



9.0

MS124780

HELICAL INSERT



HELICAL INSERT

Comment: Qty.:

1.0000 Each(s)/Unit Total:



5.0000 Each(s)

08-01 2

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

11.0

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



12.0

HAND FINISHING

HAND FINISHING RESOURCE #1



Chemical Conversion Coat as per QSI 005 4.1

QC5



13.0

POWDER COATING

POWDER COATING

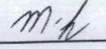




Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref. 4.3.5.8) as per QSI 005 4.3



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## **Process Sheet**

comer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

START TIME:

OVEN TEMPERATURE: FINISH TIME:

Description:

14.0

QC3



COAT/CHEMICAL CONVERSION

20 Degree Cover Plate



15.0

PB674300173

1.0000 Each(s)/Unit Total:

Comment: Qty.: 20 Degree Cover Plate batch:

5.0000 Each(s)

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total:

5.0000 Each(s)

w25 Jone

PB67-43001-83

Screw

17.0

batch: MS27039110

Comment: Qty.: 8,0000 Each(s)/Unit

Screw

batch:

40.0000 Each(s) Total:

WASHER

18.0

NAS1149F0316F

Comment: Qty.:

Total: 40.0000 Each(s)

19.0

batch: SMALL FAB 1

WASHER

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE\1

1- match drill cover to existing holes in support

2- assemble as per dwg



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Drawing Name: FWD ADJUSTABLE BLADE SUPPORT AS stomer: CU-DAR001 Dart Helicopters Services

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description: INSPECT WORK TO CURRENT STEP

20.0

QC5

05/10/23 (2)





21.0

PACKAGING 1

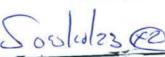
PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Chack

Location:



QC21 22.0

FINAL INSPECTIONW/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



